

# Work Order ID 73613

Wednesday, September 07, 2011 2:31:29 PM



Page 1

Item ID: D3443-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 9/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3443

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

SL 11-09-27

(6)

Jeaspa Bandsaw

Cut blank 2.400 " long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA587 Rev: \_\_\_\_ & Dwg D3443 Rev: \_\_\_\_

SL 11-10-13

P10 →

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

SL 11-10-13

(7)

Quality Control

W/O:		73613 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3443-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: A Date: 11.10.22  
 Resolution: Scrap + wear Disposition: Scrap + wear QA: N/C Closed: 11/10/25

NCR:		13295 WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10.11.12</u>	<u>110</u>	<u>Thickness 0.342 is 0.334.</u> <u>R.L Part L-thin</u> <u>2nd op. <del>off</del> Process</u> <u>USE-AS-IS</u>	<u>CP</u> <u>11.10.12</u> <u>CS/012</u>	<u>PER TR-D412-630-3, PART WAS</u> <u>TESTED LAST ULTIMATE: 540<sup>lb</sup>/521"</u> <u>(ACTUAL LOAD/REQ'D LOAD) = 1.036.</u> <u>SECTION AREA REDUCED BY 0.334/0.342</u> <u>= 0.976. 1.036 x 0.976 = 1.011.</u> <u>% PART STILL STRONG ENOUGH. ACCEPTABLE 11-10-13</u>	<u>CP</u> <u>11.10.12</u> <u>SL</u>	<u>S</u> <u>11/10/13</u>	<u>CP</u> <u>11.10.12</u> <u>CS/012</u>	<u>S</u> <u>11/10/13</u>
<u>10-11-13</u>	<u>110</u>	<u>1 part scrapped, damaged tool</u> <u>but forgot to change 2nd</u> <u>offset causing part to be</u> <u>so thin</u> <u>R.L. operator error</u> <u>Scrap</u>	<u>S</u> <u>057042</u> <u>11/10/13</u>	<u>scrap + replace qty x1</u> <u>B 114994</u>	<u>SL</u> <u>11/10/13</u>	<u>S</u> <u>11/10/13</u>	<u>S</u> <u>057042</u> <u>11/10/13</u>	<u>S</u> <u>11/10/13</u>

NOTE: Date &amp; initial all entries

# Work Order ID 73613

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Item ID: D3443-1

Revision ID:

Item Name: Lug

Start Date: 9/7/2011 Start Qty: 6.00

Required Date: 9/22/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: Perre L

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

*Perre L 11/10/17*

*11/10/17  
ME  
11-10-17*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 07, 2011 2:31:25 PM

Page 1

Work Order ID: 73613

Parent Item: D3443-1

Parent Item Name: Lug



Start Date: 9/7/2011

Required Date: 9/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: A: 05.11.14 New issue EC  
IPP Rev:B Removed Tumbling 08-09-08 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M174B2.500X1.250

Purchased

No

100

f

9.6470

0.2

1.263158



2L 11-09-27

17-4 SS BAR 2.500 x 1.250

Location

Loc Qty

Loc Code

MAT050

9.647

114994

9.647

1.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 73613
Description: Lug		Part Number: D3443-1
Inspection Dwg: D3443	Rev: C	Page 1 of 1

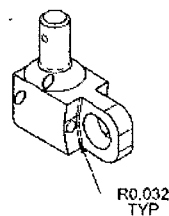
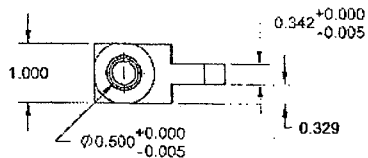
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

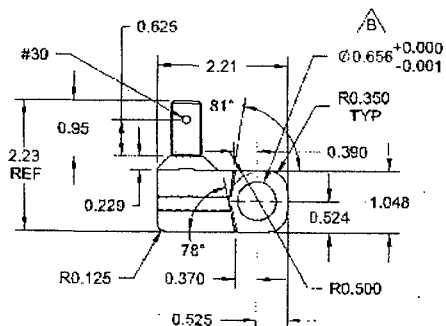
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	✓		REN 3-3	
0.342	+0.000/-0.005	.341	✓			
0.329	+/-0.010	.330	✓			
Ø0.500	+0.000/-0.005	.500	✓			
2.21	+/-0.030	2.216	✓			
Ø0.656	+0.000/-0.001	.6552	✓			
0.625	+/-0.010	.629	✓		H-G	
0.95	+/-0.030	.953	✓		H-G	
2.230	+/-0.010	2.224	✓			
0.229	+/-0.010	.230	✓		H-G	
0.370	+/-0.010	.373	✓			
0.525	+/-0.010	.525	✓			
0.524	+/-0.010	.524	✓			
0.390	+/-0.010	.390	✓			
1.048	+/-0.010	1.042	✓			
0.05 x 45°	+/-0.5°	.05x45°	✓			
R0.032	+/-0.010	.030	✓			
0.470	+/-0.010	.468				
0.165	+/-0.010	.166				
1/4-28UNF	N/A					

Measured by: SL	Audited by: SA	Prototype Approval:	N/A
Date: 11-10-13	Date: 11/10/14	Date:	N/A

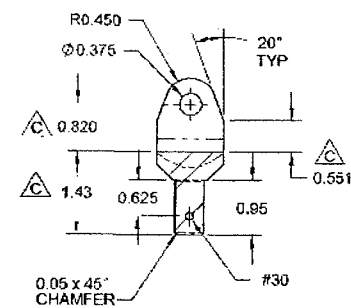
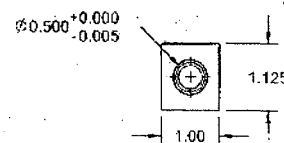
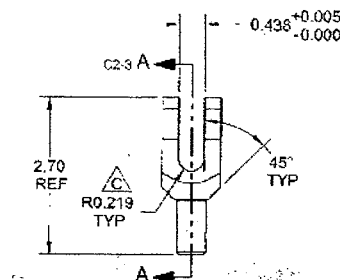
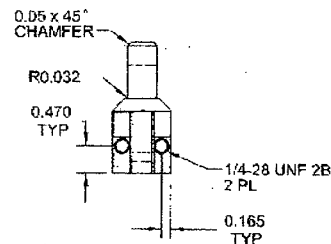
Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM	
B	09.11.04	Dwg Rev updated	KJ	



w/o 73613



D3443-1 LUG



SECTION A-A C4-3

D3443-3 CLEVIS

RELEASED  
09/18/25

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)  
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs  
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS ORIGINALLY DESIGNED AND NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE LTD.	